

2. a plurality of caster mounting tubes, each mounting tube including a plurality of external side walls each having an interior surface and an exterior surface, the interior surface being configured to receive the sleeve of a caster, the plurality of external side walls including a generally planar first external side wall, the exterior surface of the first external side wall abutting the base frame, the mounting tube being connected to the base frame by welds located adjacent the first external side wall.

7. (Amended) A patient support apparatus comprising:
a base frame,
a patient support coupled to the base frame,
a plurality of casters each having a sleeve, and
a plurality of caster mounting tubes, each mounting tube having an interior configured to receive the sleeve of a caster, a plurality of external side walls including a generally planar first external side wall abutting the base frame, the mounting tube being connected to the base frame by welds located adjacent the first external side wall, wherein the plurality of casters each include a set screw to orient the caster and the caster mounting tubes are each formed to include a notch configured to receive one of the set screws.

11. (Amended) A method for attaching a caster having a cylindrical sleeve to a base frame of a bed, the method comprising the steps of:
providing a caster having a cylindrical sleeve, a mounting tube having four side walls configured to provide a substantially rectangular cross-sectional shape, and a base frame of a bed;
forming an interior opening through the mounting tube having a generally round cross-sectional shape to receive the cylindrical sleeve of the caster therein;
placing a first side wall of the mounting tube against an external surface of the base frame;

welding the mounting tube to the base frame with first and second welds located at opposite ends of the first side wall; and installing the sleeve of the caster into the interior opening of the mounting tube.

12. (Amended) A method for attaching a caster having a cylindrical sleeve to a base frame of a bed, the method comprising the steps of:

providing a caster having a cylindrical sleeve, a mounting tube having four side walls configured to provide a substantially rectangular cross-sectional shape, and a base frame of a bed;

forming an interior opening through the mounting tube having a generally round cross-sectional shape to receive the cylindrical sleeve of the caster therein;

placing a first side wall of the mounting tube against the base frame;

welding the mounting tube to the base frame with first and second welds located at opposite ends of the first side wall;

installing the sleeve of the caster into the interior opening of the mounting tube; and

wherein the caster includes a set screw to orient the caster, the method further comprising the step of forming a notch in the mounting tube to receive the set screw of the caster.

15. (Amended) The method of claim 11, wherein the welding step includes providing a two axis welding machine

16. (Amended) A method for attaching a caster to a base frame of a bed, the method comprising the steps of:

providing a mounting tube having four side walls configured to provide a substantially rectangular cross-sectional shape;